

## WHAT IS CLAIMED IS:

1. An injection-molded product formed in accordance with injection molding by mixing a foaming agent in a molding resin material, wherein
  - 5 the injection-molded product is formed by molding using a mold having a heat insulating material on a surface of a cavity thereof forward in a moving direction of a portion where the molding resin material molten and injected for forming the molded product has an injection speed of at least 1.5 m/sec to 2,000 m/sec  
10 in the cavity of the mold.
  2. The product according to claim 1, characterized by being molded by using a mold in which the heat insulating material is formed around a gate on the  
15 surface of the cavity of the mold.
  3. The product according to claim 1, characterized by being molded by using a mold in which the heat insulating material has a thickness of 0.07 mm to 0.15 mm.
- 20 4. A mold for injection molding, for forming, by molding, an injection-molded product by mixing a foaming agent in a molding resin material and injecting the foaming-agent-mixed molding resin material, wherein
  - 25 the mold for injection molding has a heat insulating material on a surface of a cavity thereof forward in a moving direction of a portion where the molding resin material molten and injected for forming

the molded product has an injection speed of at least 1.5 m/sec to 2,000 m/sec in the cavity of the mold.

5. The mold according to claim 4, wherein the heat insulating layer is formed around a gate on the surface  
5 of the cavity of the mold.

6. The mold according to claim 4, wherein the heat insulating material has a thickness of 0.07 mm to 0.15 mm.

7. An injection molding method of forming, by  
10 molding, an injection-molded product by mixing a foaming agent in a molding resin material and injecting the foaming-agent-mixed molding resin material, wherein molding is performed by using a mold having a heat insulating material on a surface of a cavity  
15 thereof forward in a moving direction of a portion where the molding resin material molten and injected for forming the molded product has an injection speed of at least 1.5 m/sec to 2,000 m/sec in the cavity of the mold.

20 8. The method according to claim 7, wherein molding is performed by using a mold in which the heat insulating layer is formed around a gate on the surface of the cavity of the mold.

9. The method according to claim 7, wherein molding  
25 is performed by using a mold in which the heat insulating material has a thickness of 0.07 mm to 0.15 mm.